Date;

Monday, 7/30/2007 1:53:59 PM

User:

Kim Johnston

Process Sheet

*Customer Job Number : CU-DAR001 Dart Helicopters Services

: 11927

Estimate Number P.O. Number

This Issue

Prsht Rev.

First Issue

Previous Run

: 111

: 7/30/2007

S.O. No. : NA

: MACHINED PARTS

Project Number **Drawing Revision**

> Material **Due Date**

Drawing Name

Part Number : D2005003

D2005003 REV E

: RESTRICTOR

Drawing Number : N/A

: 8/20/2007

Each

Written By Checked & Approved By

Comment

: Est.

F63.04.30

Reformat; Made on Cobra KJ/RF

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0 M303R0500

303 Round Bar 0.500"



Comment: Qty.:

0.0547 f(s)/Unit Total:

0.2735 f(s) 303 Round Bar 0.500"

Material: Ø1/2" AISI 303 Round Bar (M303R0.500) or Ø7/16" AISI 302/304 SS Round Tubing 0.065" wall

Batch M 196292

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

Turn blank as per Folio FA275 Deburr

QC2 3.0



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:_ *

Dart	Aeros	pace	Ltd
------	-------	------	-----

W/O:		WORK ORDER CHANGES									
DATE	STEP PROCEDURE CHANGE		STEP PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
			•								
							,				
					\bigcirc			1 1			

Part No:	PAR #:	Fault Category: _	 NCR: Yes No	DQA:	Date: _	aliali
			QA: N/C	Closed:	Date: _	

	WORK ORDER NON-CONFORMANCE (NCR)							
•	Description of NC		Corrective Action Section B		Varification	Annaval		
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector	
					•			
							, 5	
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Section A Initial Action Description Sign & Section C	STEP Description of NC Section A Section B Section B Verification Approval Chief Eng	

NOTE: Date & initial all entries

Date:

Monday, 7/30/2007 1:53:59 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RESTRICTOR

Job Number: 33793

Part Number: D2005003

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mi roorlielich

Dart Aerospace Ltd

W/O:		WORK ORDER CHA	ANGES	·			
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				•	-		
Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	A :	Date:	

QA: N/C Closed: ____ Date: ____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section E		Verification	Ammassal	Ammerical			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto			
				•	:						
		·									

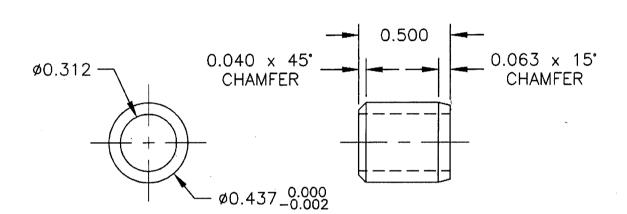
NOTE: Date & initial all entries





DESIGN	ı JB	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECK	EDH-	APPROVED	DRAWING NO. D2005-003 SHEET	REV. E 1 OF 1
DATE			TITLE	SCALE
03.0	5.01		RESTRICTOR	2:1
С		96.04.17	REDRAWN	
D		97.09.03	304 S.S. SPEC ADDED	
Ε		03.05.01	ADDED TOLERANCE TO Ø0.437	





NOTE:

1) MATERIAL: Ø0.50 AISI 303 ROUND BAR (REF DART SPEC.

M303R0.500) OR Ø0.435 AISI 302/304/316 SS 0.065

WALL SEAMLÉSS ROUND TUBING (REF. DART SPEC.

M304TR0.375W.065)

SHOP COPY

RETURN TO ENGINEERING

2) FINISH: NONE

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE CHOREDLED COPY

4) ALL DIMENSIONS ARE IN INCHES

SUBJECT TO AMENDMENT

5) BREAK ALL SHARP EDGES 0.005 TO 0.010

WITHOUT NOTICE

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DART AEROSPACE LTD	Work Order: 33	793
0		
Description: PUSTRICTOR	Part Number: D2009	2003
Inspection Dwg 2005-003 Rev:	Page	e 1 of 1

Inspection Dwg	6/005-003Rev:	<i>U</i>		_1		P	age 1 of 1
	•	ARTICLE IN	SDECTIO	N CHE	CKLIST		
	FIRST	First Artic		Proto			
		ı r]	1		
Drawing	Tolerance	Actual Dimension	Accept	Reject	Method o Inspectio		omments
Dimension	105 -,001						
.312	t/ wit	1315					
- 437	002	1436					
- 500	+/010 +/010 +/.5 +/010+/5	1701	i				
1040 ×45	1-1010 7 13	1035 X43					
,065 x/S	7010 4.5	.062 × 15					
					<u> </u>		
				-			
					,		•
			=				
Measured by:	EP	Audited by:	TF.	Р	rototype A		
Date:	07/0/07	Date:	07/12/	67		Date:	
Rev Date	Change	,			· ·	Revised b	y Approved
A Data	Now Issue					KJ/RF	

		<i>t</i> /	Revised by	Approved
Rev	Date	Change		Apploved
Α		New Issue	KJ/RF	
	L			

